

Delev 54429

Work Order ID 52381

Tuesday, September 22, 2009 11:49:05 AM



Item ID: D3531-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *RF MF* Date: *09-9-22*

Tooling:

Date:

Run Start



QC: _____

Date:

SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3531	Rev A
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100	Small Fab	0.00
Small Fab	Memo	0.00
Small Fab	Assemble as per dwg D3531	

09/12/03 (11)

110	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

27 09/12/03

(11) */*

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00
Powdercoat	Memo	0.00
Powder Coating		

M 190091

BL 09-12-8

(11)

START TIME: *2:00* □OVEN TEMPERATURE:
320° □FINISH TIME: *2:30*

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Item ID: D3531-041

Accept

Revision ID: A

Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/9/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

M 09/12/09

(X11)

Ø

140

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

09/12/09 (11)

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/09

u 09.12.09

Picklist Print

Tuesday, September 22, 2009 11:49:05 AM

Page 1

Work Order ID: 52381



Parent Item: D3531-041RevA



Parent Item Name: Bracket Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3531-1RevA		Manufactured	No			100	Each	0.0000	6.0000			
						B 53023					SA 09/11/30	
Bracket												
D3531-3RevA		Manufactured	No			100	Each	14.0000	6.0000			
Bracket Front Plate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

35379

2

50214

12

2 SA 09/11/30
9

MS20470AD4-4

Purchased

No



Rivet, Universal Head

100

Each

4,732.000

72.0000



8509/12/03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4732

111359

88

112314

4644

132

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

△
4
TRANSFER DRILL #9 (Ø0.196)

TRANSFER DRILL #30 (Ø0.129)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

RELEASED
07-08-03

D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52381

MS20470AD4-4
(10 PLACES)

D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

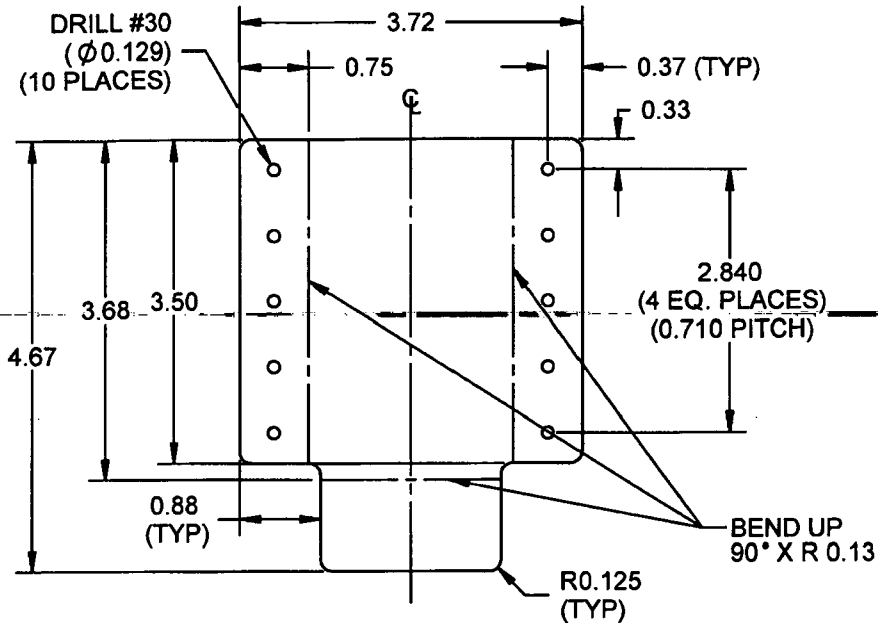
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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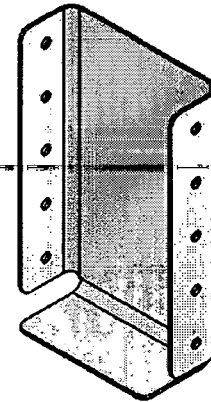
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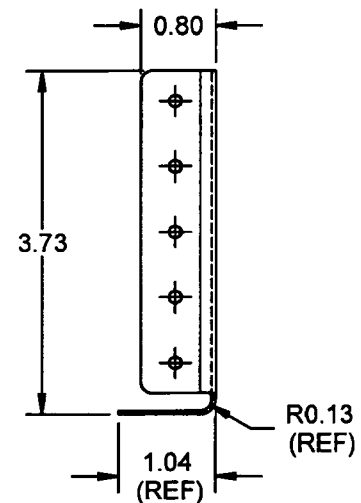
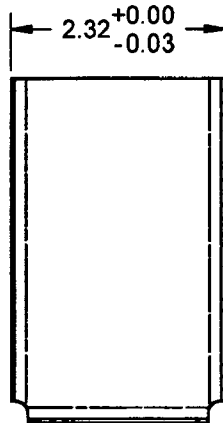
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



RELEASED
07.08.03



D3531-3F FLAT PATTERN



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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